

# Work Order ID 96851

February-07-13 10:38:52 AM

\*96851\*

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Item ID: D4659-2 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket, RH  
 Start Date: 2/07/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 2/13/13 Req'd Qty: 4.00 \*4\* Customer:

## Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4659	<del>742</del> A <del>DA</del>								
100		0.00							
*100*	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4659 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

SMP  
B2-7

4 0 Jm B-2-7  
 4 0 Jm B-2-7  
 4

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Item ID: D4659-2 Accept \*N900040100\* Setup Start \*NS1\*  
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 Start Date: 2/07/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 2/13/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE  Memo Bend as per Dwg D4659	0.00  0.00				4			8/13/02/11
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				4			AS 15 13-3 11
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3 5.6) per Q81005 4.3 M 122966 Memo	0.00  0.00				4			4 132-12

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Item ID: D4659-2 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket, RH  
 Start Date: 2/07/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 2/13/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165 *165* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				4			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 237A</u>  Memo	0.00 0.00				4x		SD 13-2-13	
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						13/2/14 JD	

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# Picklist Print

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Work Order ID: 96851

Parent Item: D4659-2

Parent Item Name: Bracket, RH

Start Date: 2/07/13

Required Date: 2/13/13

Start Qty: 4.00

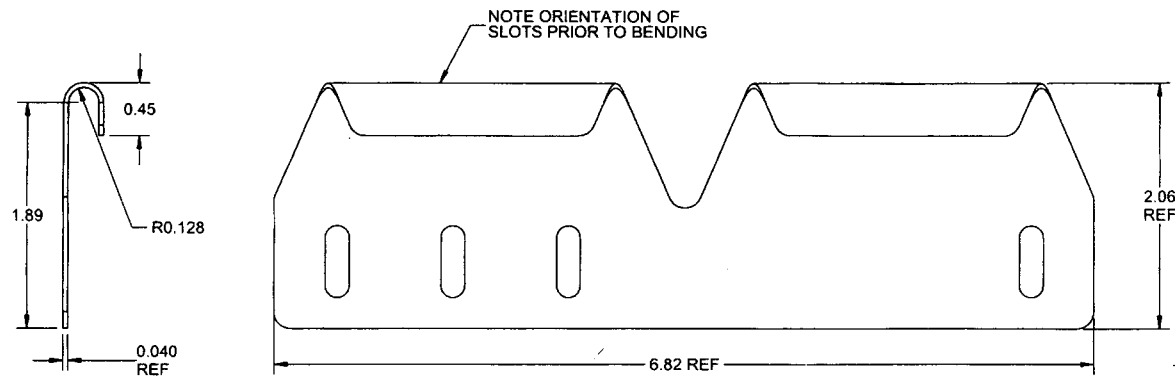
Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-06-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	329.1001	0.145	0.6105263			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		329.100065							
				121380		0.000065							
				122732		32							
				122753		98.8							
				124029		198.3							
										24029			

Im 13.2.7





**D4659-1 BRACKET, LH**

**RELEASED**  
2012-06-13

**NOTES:**

- 1) MATERIAL: MAKE FROM D4659-1F
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4659-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.25 lbs.

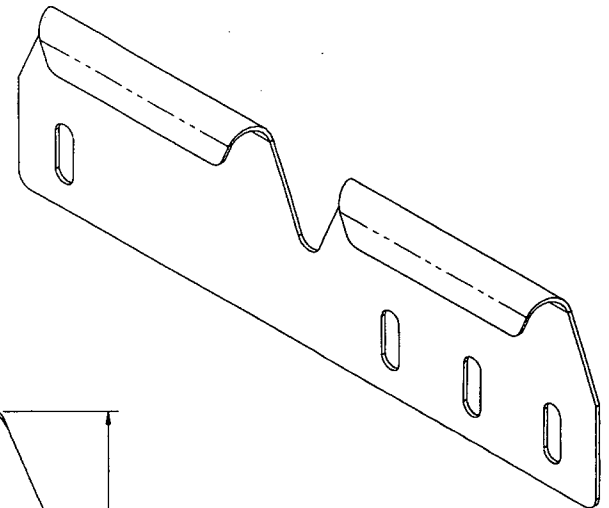
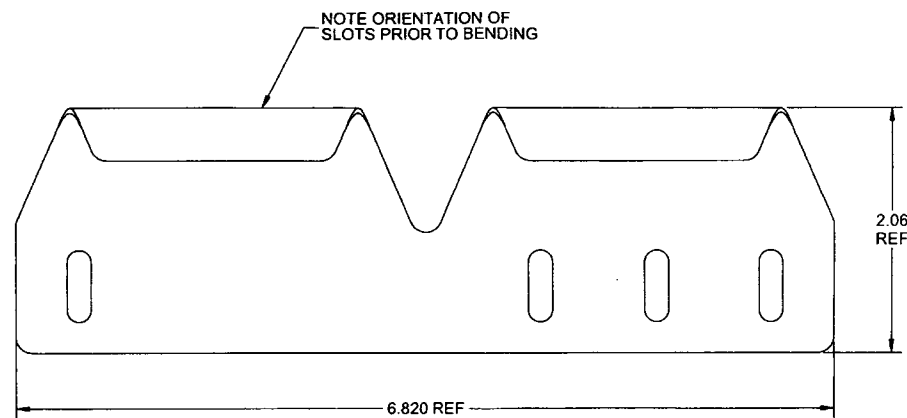
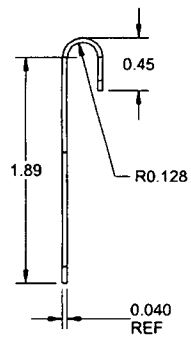
*W/086851*

REV.	NEW ISSUE	DESCRIPTION	RP	12.06.08
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.06.08			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4659</b>	REV. A
TITLE <b>BRACKET</b>	SCALE NTS

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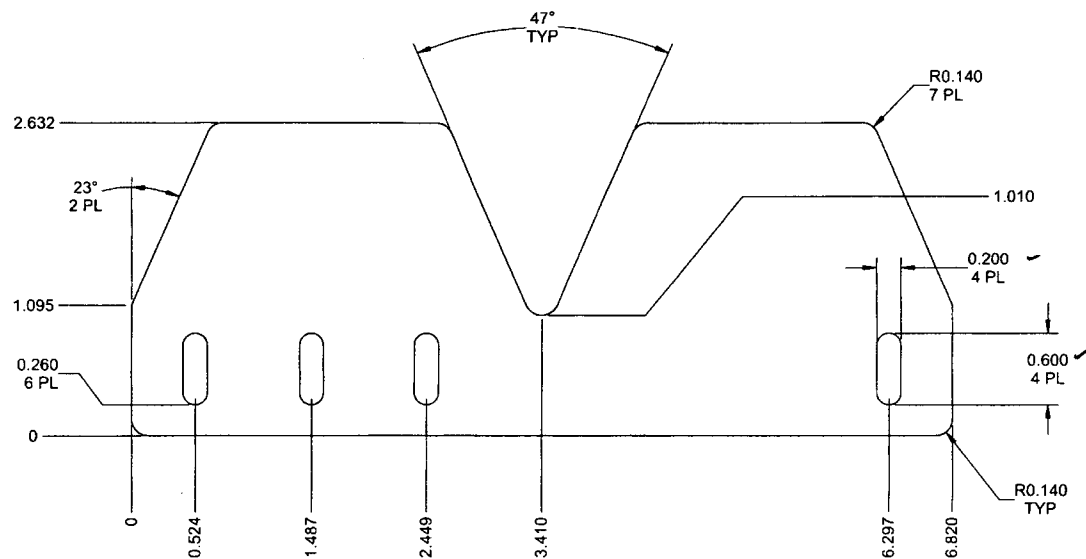


**D4659-2 BRACKET, RH**

**RELEASED**  
2012-06-13

- NOTES:**
- 1) MATERIAL: MAKE FROM D4659-1F
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4659-2" AND B/N "BXXXXX" PER QSI 044 6.1
  - 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4659</b>	SHEET 2 OF 3
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DE APPR.		<b>BRACKET</b>	NTS
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**D4659-1F BRACKET (FLAT PATTERN)**

**RELEASED**  
2012-06-13

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

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